












Date: Monday, 11/12/2007 11:46:14 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HI-STEP LEG ASSEMBLY
Job Number : 35625	
Estimate Number : 10385	
P.O. Number :	Part Number : D3065041
This Issue : 11/12/2007 S.O. No. :	Drawing Number : D3065 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision :
Previous Run : 35622	Material :
Written By : <u>[Signature]</u>	Due Date : 12/19/2007 Qty: <u>50</u> Um: <u>✓</u> Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev: C 02.11.01 Incorporated D3066-1 IPP KJ/RF	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	D30651 Step Spacer
	
	
Comment: Qty.: 1.0000 Each(s)/Unit Total : <u>50</u> 100.0000 Each(s) Step Spacer B <u>35614</u>	
2.0	D30653 Step Spacer
	
	
Comment: Qty.: 1.0000 Each(s)/Unit Total : <u>50</u> 100.0000 Each(s) Step Spacer B <u>35615</u>	
3.0	D30655 Step Leg
	
	
Comment: Qty.: 2.0000 Each(s)/Unit Total : <u>100</u> 200.0000 Each(s) Step Leg B <u>35620</u>	
4.0	D30657 Step Spacer
	
	
Comment: Qty.: 1.0000 Each(s)/Unit Total : <u>50</u> 100.0000 Each(s) Step Spacer B <u>35616</u>	
5.0	MS20470AD44 Rivet, Universal Head
	
	
Comment: Qty.: 30.0000 Each(s)/Unit Total : <u>1500</u> 3000.0000 Each(s) Rivet, Universal Head Pick: Qty Part Number Description Batch 30 MS20470AD4-4 Rivet <u>M106654</u>	
<div style="text-align: right;"> <u>1370X</u> <u>1355X</u> <u>M106552</u> <u>130X</u> <u>[Signature]</u> </div>	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/12/2007 11:46:14 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 35625

Part Number: D3065041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



P70

Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3065 and Identify as D3065-041

Bos 08/04/16

MF 08-04-16

50

7.0

QC5

INSPECT WORK TO CURRENT STEP



counters

Comment: INSPECT WORK TO CURRENT STEP

8 08/04/17 XSD

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WH

08-04-17

50

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/18

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3065-041 PAR #: 11A Fault Category: Prod/Process ^{Med & Small} NCR: Yes No DQA: D Date: 08/04/18
D350-591 QA: N/C Closed: D Date: 08/04/21

NCR: <u>35625</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-04-16	6.0	1x D3065-041 is missing 3 rivets, and 1 hole in the D3065-1 is oversized due to drilling - replacing A rivet. Found upon inspection, Employee did not verify work for completeness.	<i>[Signature]</i>	Added 3 rivets to complete Assembly, and replace the D3065-1, and scrap the existing one on the ASSY MS20470AD4-4B, 1106652 Qty 3 D3065-1 B35614 Qty 1	<i>[Signature]</i> 08/04/17	<i>[Signature]</i> 08/04/17	<i>[Signature]</i> 08/04/17	<i>[Signature]</i> 08/04/17
08-04-16	6.0	1x D3065-041 is missing 1 rivet pressed. Rivet is installed, but not pressed.	<i>[Signature]</i>	Complete the ASSY, and verify all work, and parts. (Inspect) before inspection.	<i>[Signature]</i> 08/04/17	<i>[Signature]</i> 08/04/17	<i>[Signature]</i> 08/04/17	<i>[Signature]</i> 08/04/17
		1x D3065-041, the (1) rivet in the ASSY appears to be very small, thin, and flat, after being pressed. Does <u>not</u> look like the others.	<i>[Signature]</i>	Carefully remove rivet to inspect to hole size on the D3065-1.	<i>[Signature]</i> 08/04/17	<i>[Signature]</i> 08/04/17	<i>[Signature]</i> 08/04/17	<i>[Signature]</i> 08/04/17

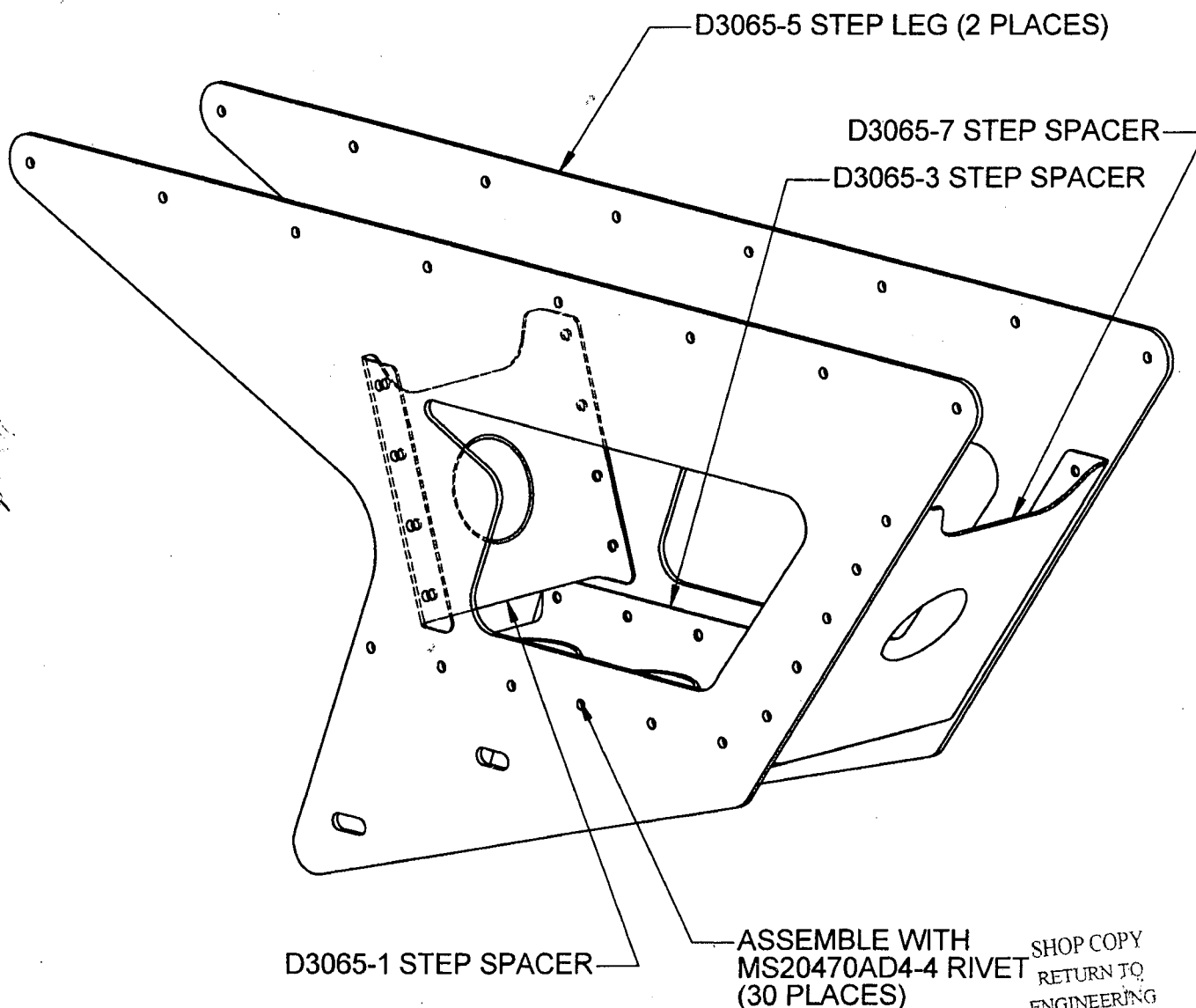
NOTE: Date & initial all entries



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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*



D3065-041 STEP LEG ASSEMBLY

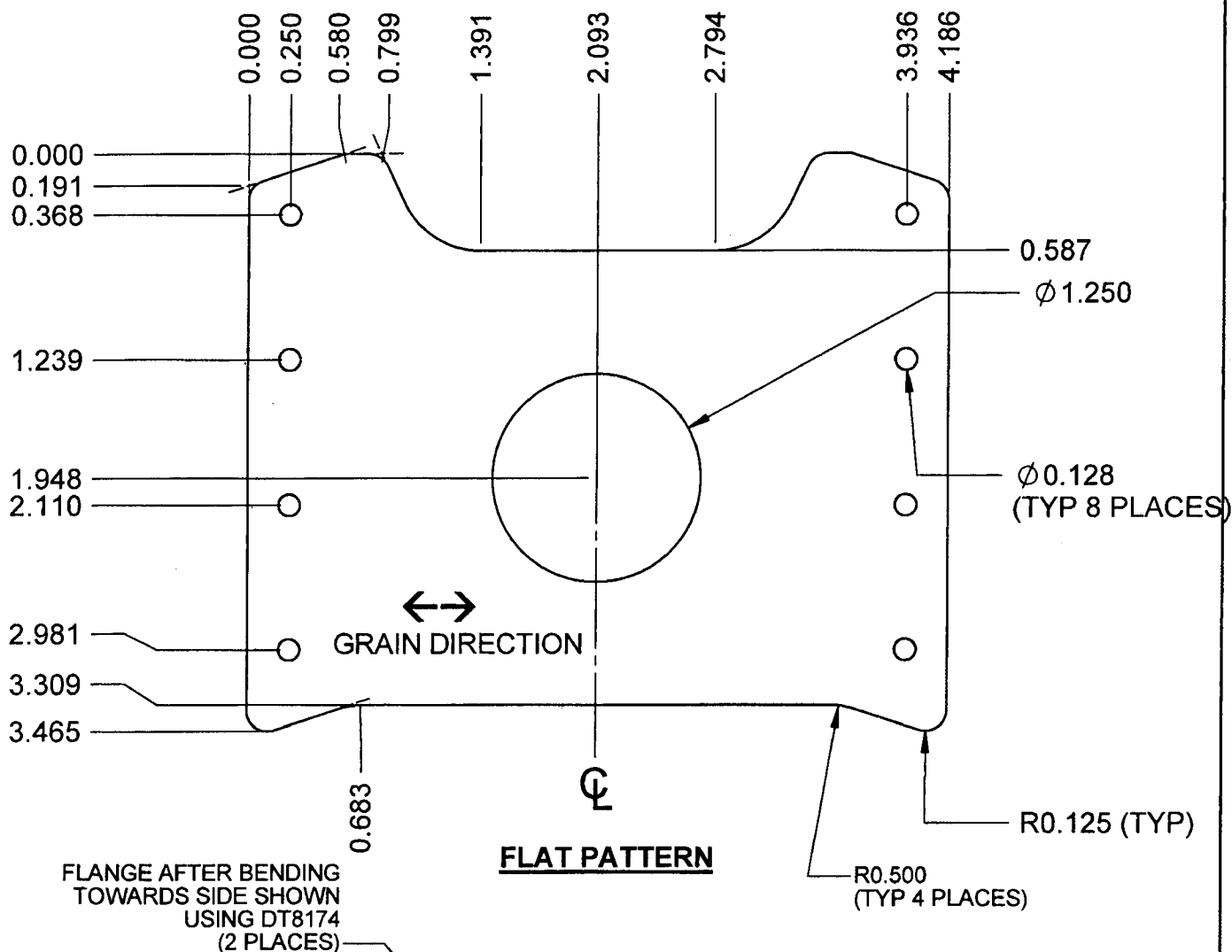
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DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



RELEASED

cl. de-ro

D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

BEND DETAIL

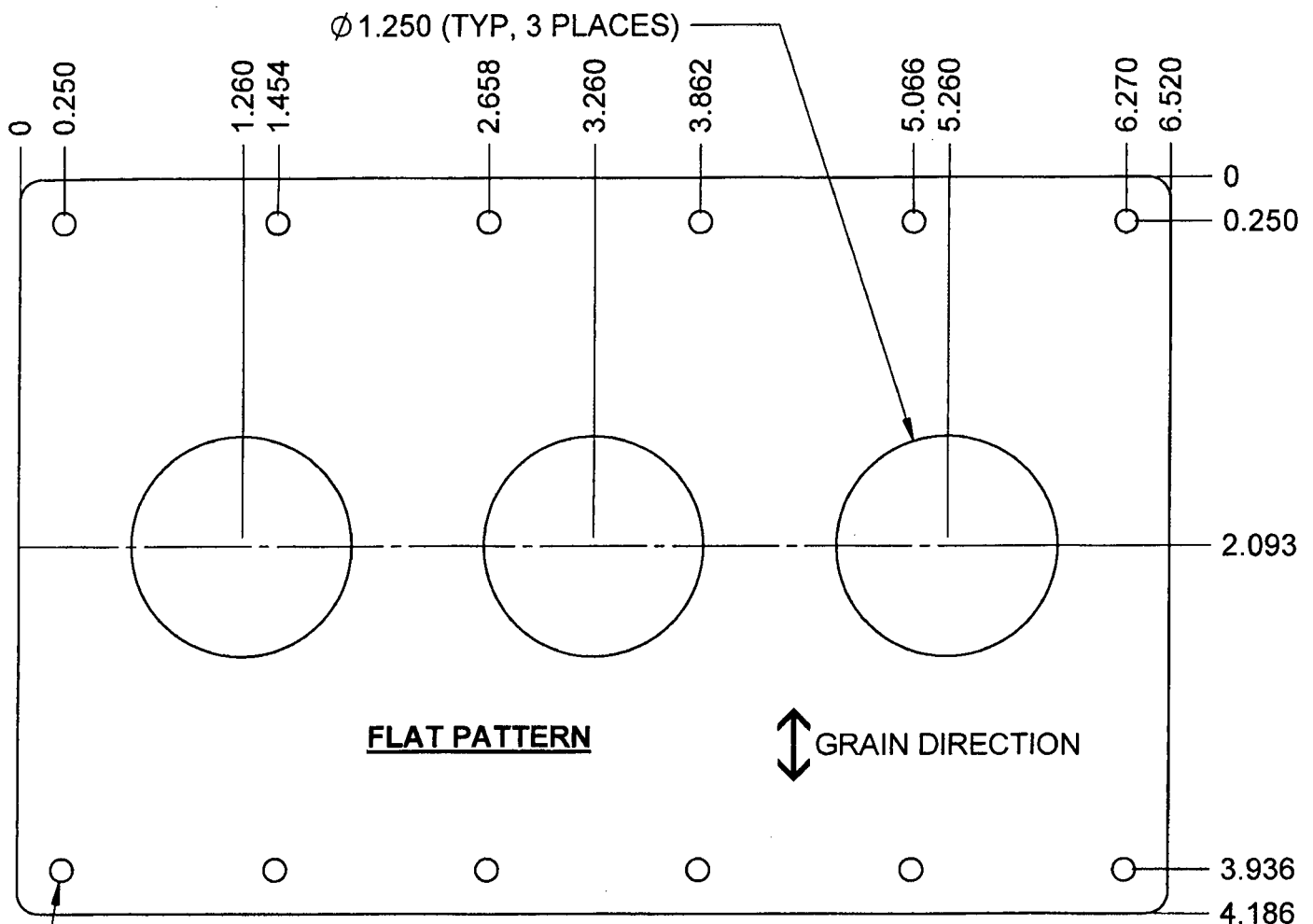
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DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

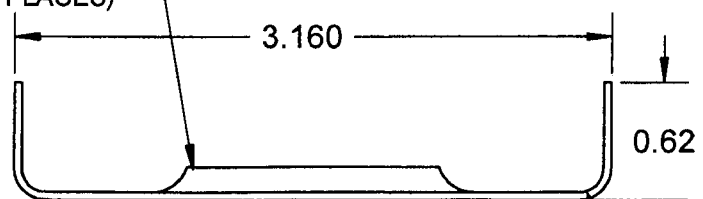


FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

RELEASED

06 Oct 20 *[Signature]*



BEND DETAIL

D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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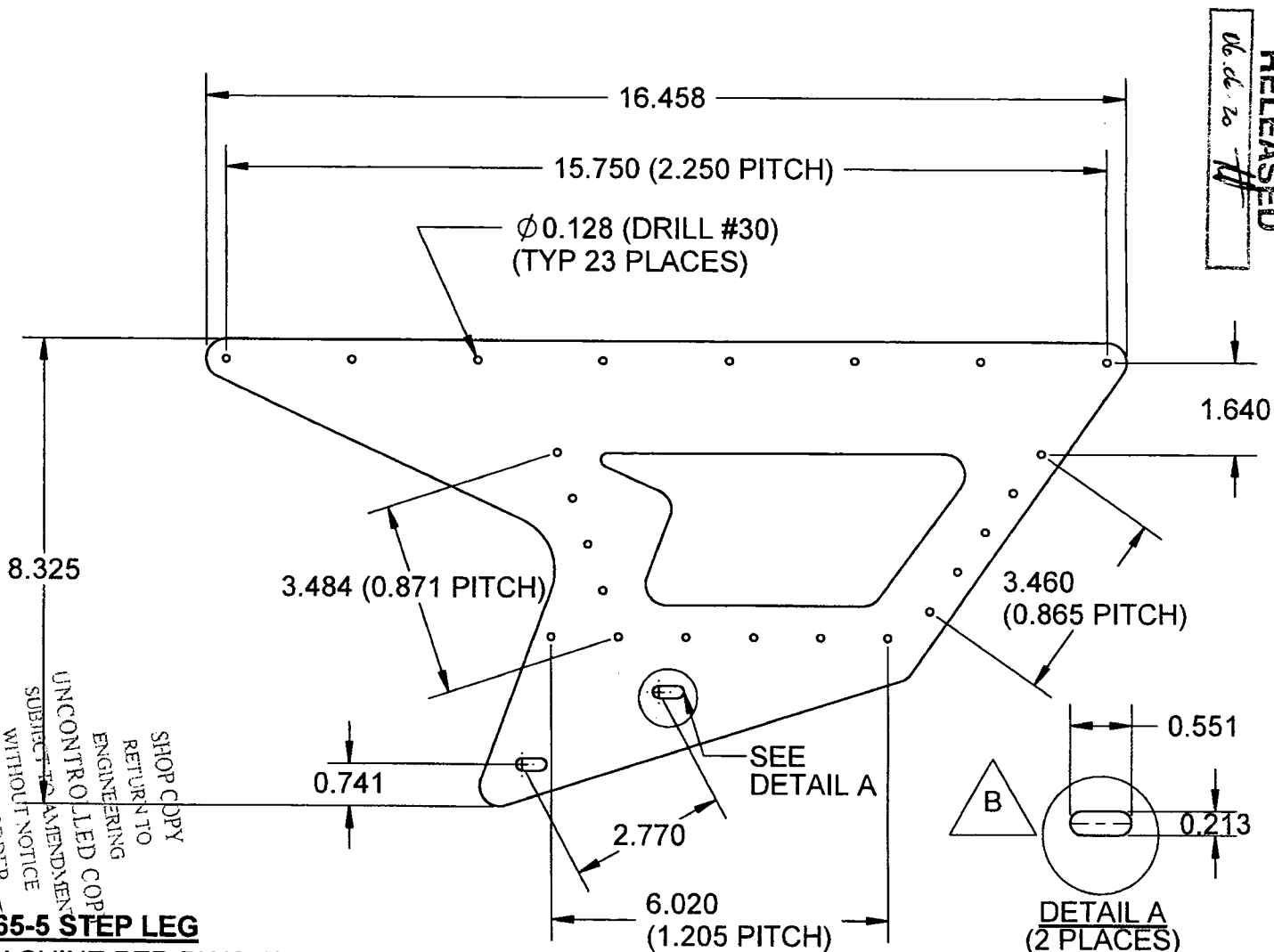
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DATE 06.05.23		D3065	SHEET 4 OF 5
	TITLE	STEP LEG ASSEMBLY	
		SCALE	1:3

RELEASED

de de 20 11



D3065-5 STEP LEG

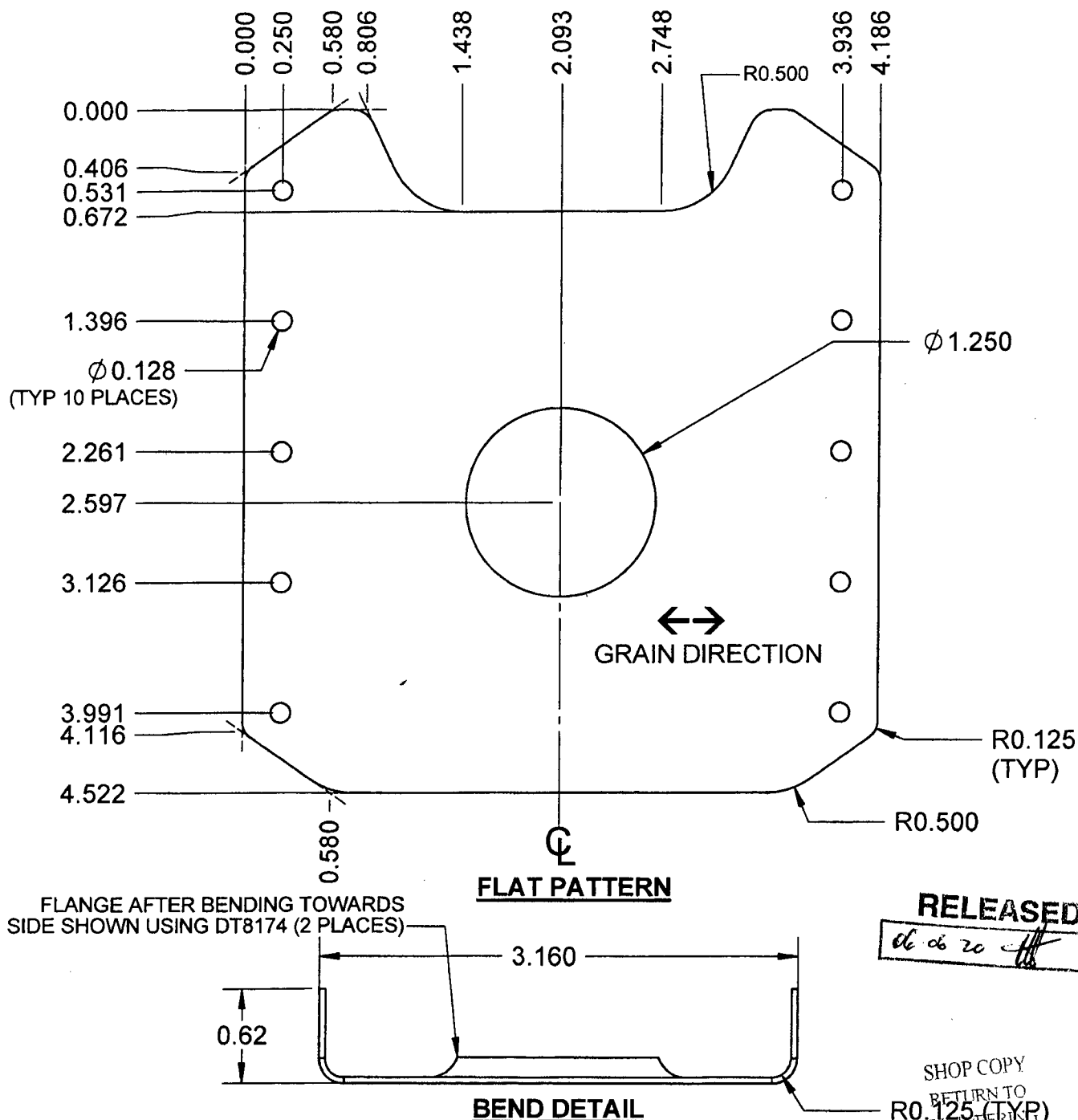
- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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